



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D350-636-022
Job Sheet 192286



Part No: D350-636-022

Job Qty: 1 ea

Part Name: AS350/355 - Skidtube - Standard w/ Standard Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D2750-052 REV.H, IIN-D350-636 REV.K IPP REV.A 18.11.27 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

5171851RH



Dart Aerospace Ltd.
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Container No: S171851



Part: D350-636-022

Job No: 192286

Serial No/Batch: S171851

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA STC

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/19/19	4/19/19	0.00	0.00	Start Up Skid tubes-1		BE
110	Skid tubes	1 pcs	4/19/19	4/19/19	0.00	4.36	Skid tubes-4		BE
120	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC10		CPC DAS
130	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC5		MAY 01 2019 68
140	HandFinish	1 pcs	4/19/19	4/19/19	0.00	0.91	HandFinish1		D.R. 19/09/2019
150	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC7-2		BE
160	Skid tubes	1 pcs	4/19/19	4/19/19	0.00	4.36	Skid tubes-1		BE
170	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC10		CPC
180	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC5		CPC
190	HandFinish	1 pcs	4/19/19	4/19/19	0.00	0.91	HandFinish2		MAY 27 2019
200	SprayPaint	1 pcs	4/19/19	4/19/19	0.00	0.69	Spray Paint		AS 19-5-23
205	Outsource	1 pcs	4/19/19	4/19/19			ATE003-VC	5	NR
210	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC14		M 19-5-29
230	HandFinish	1 pcs	4/19/19	4/19/19	0.00	0.91	HandFinish4		M 19-6-29
240	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC5		JUN 07 2019 9-89
250	Packaging	1 pcs	4/19/19	4/19/19	0.00	0.00	Packaging1-3		JRB 6/10/19
260	QC	1 pcs	4/19/19	4/19/19	0.00	0.00	QC4		JRB 6/10/19
270	Packaging	1 pcs	4/19/19	4/19/19	0.00	0.00	Packaging3-1		JRB 6/10/19
275	DC	1 pcs	4/19/19	4/19/19	0.00	0.00	DC		DAS 21 9-89 JUN 10 2019
280	QC21-FG	1 Ea	4/19/19	4/19/19	0.00	0.00	QC21		9-89

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 (D2750-6 details). Drill using drill Jig DT8150. 4- Locate Descriptions: DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail BM to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail BN using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BN, ground handling and float holes per dwg D2750 (welding instructions on sheet 16) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date: 12-07-2019 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 1309011 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint. + A/R M139011

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5179552 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5184740

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5174342 EXP DATE: 16-12-16 5- Coat all exposed fasteners with "LPS Procyon" batch: M133696

270 - Package as per PPP D350-636-012

275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-012 CHG 008

010248

Job BOM					010067
Part / Item	Component Name	Quantity	Operation	Container	
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Start up Operation	5166246	
D2744	Cap	1 pcs (1 ea)	110-Skidtubes	5150391	
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes	5153407	
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes	5162846	
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5174233	
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5174233	
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5176396	
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	516098	
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5163736	
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-HandFinish	5186162	
D3537-1	Wearpad	3 pcs (3 ea)	230-HandFinish	5181203	
D3631-1	Washer	8 pcs (8 ea)	230-HandFinish	5181118	
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5180555	
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-HandFinish	5176167	
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-HandFinish	5186226	
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5181777	
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5167203-1	
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5158678	
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2	
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083556	
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5167517	
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5161972	
D3793-5	Wearpad	1 pcs (1 ea)	230-HandFinish	5099559	
MS21043-3	Nut	1 Ea (1 ea)	230-HandFinish	5135100	
NAS1149C0363R	Washer	2 Ea (2 ea)	230-HandFinish	5186091-1	
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5149198	
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging	5149549	
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5167203	
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5166718	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	2	0
110-Skidtubes	D2744	1	34	0
160-Skidtubes	D2739	1	15	0
	D2743	8	192	0
230-HandFinish	ALS4-1032-225	38	937	0
	AN3C34A	1	14	0
	AN3C5A	34	1,446	0
	AN3C6A	4	164	0
	AN6C44A	4	143	0
	AN8C35A	1	36	0
	D2745	8	240	0
	D3488-4	1	7	0
	D3537-1	3	45	0
	D3631-1	8	285	0
	D3791-1	1	12	0
	D3793-1	1	17	0
	D3793-3	1	13	0
	D3793-5	1	24	0
	MS21043-3	1	966	0
	MS21043-6	4	147	0
	MS21083C8	1	87	0
	NAS1149C0332R	38	5,083	0
	NAS1149C0363R	2	567	0
	NAS1149C0832R	1	349	0
	NAS1515H3L	4	394	0
250-Packaging	AN8C21A	2	111	0
	D2741	1	77	0
	MS21083C8	2	87	0
	NAS1149D0863J	2	123	0

Part Specifications
Specifications could not be found.

Plex 3/20/19 11:55 AM Dart.lajeunesse.marie

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	AL54-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. 192286 MJS
19-03-20

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2018 OCT 19
2018-08-03

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-1/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-1/-12/-13/-14); NAS1149C0332R REPLACES AN960C10L (ZN A5-1, B1-1/-12/-13/-14, C7-1/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-1/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3781-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	

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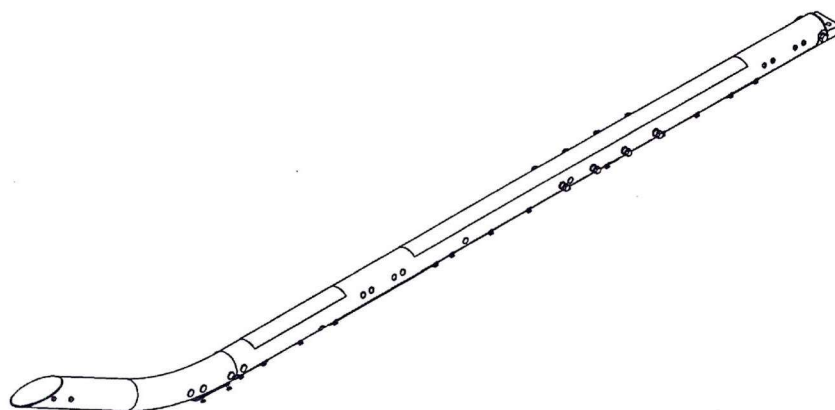
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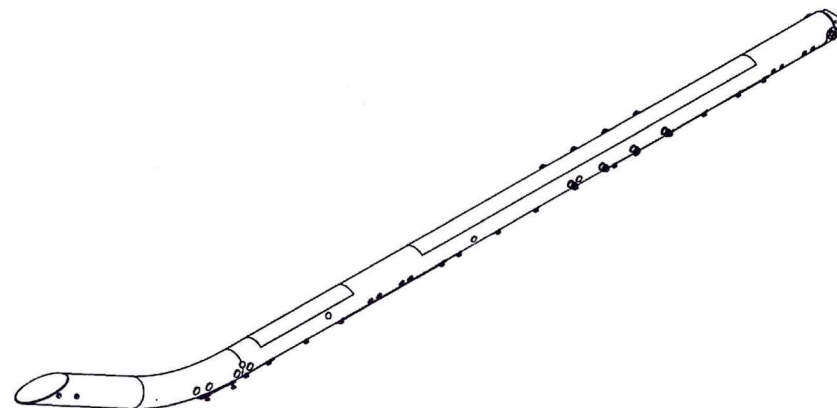
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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2018 10-19

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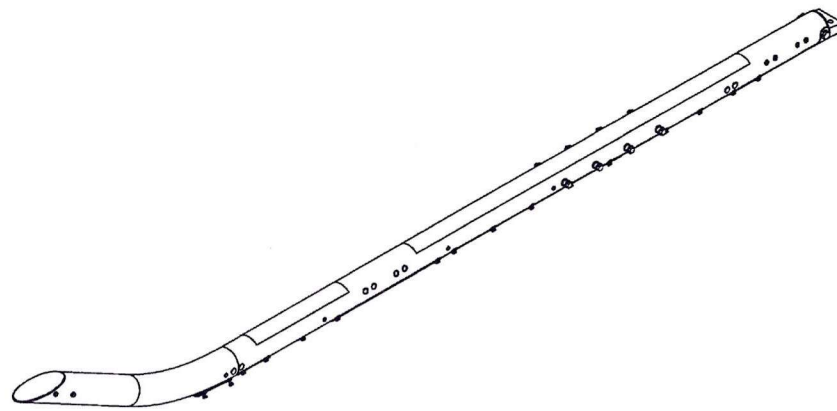
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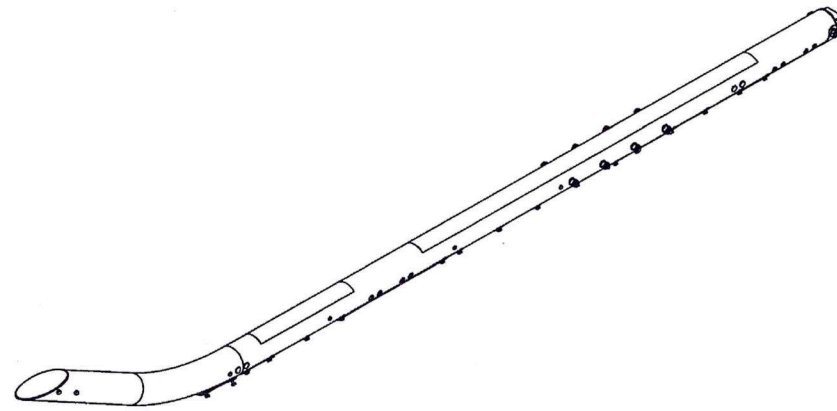
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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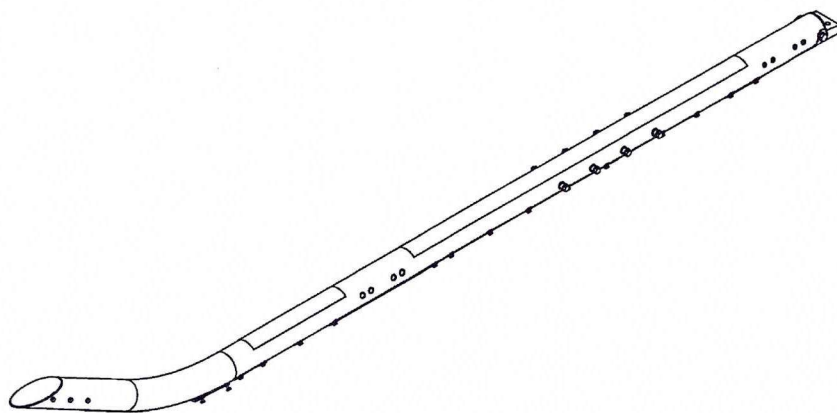
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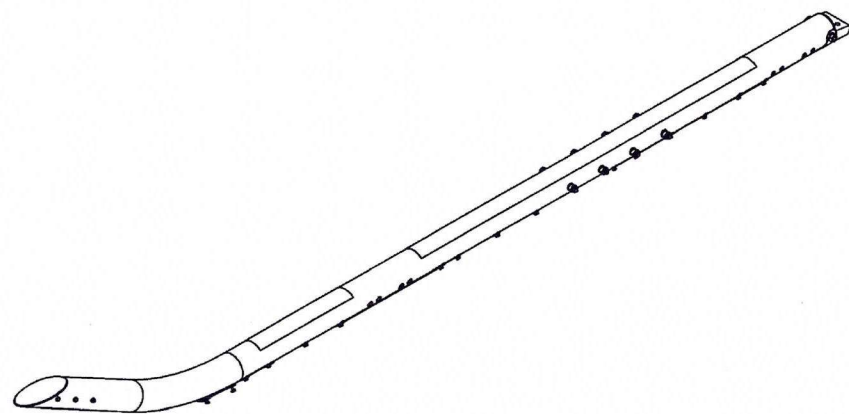
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 **D2750-051 350 SKIDTUBE ASSEMBLY, LH**



 **D2750-052 350 SKIDTUBE ASSEMBLY, RH**

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2018 OCT 19 *17*

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MFG. APPR.	DD	SHEET 4 OF 16	
APPROVED	NO	TITLE	SCALE
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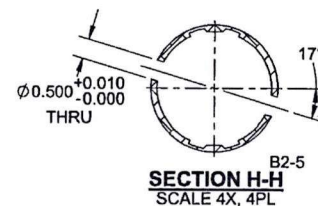
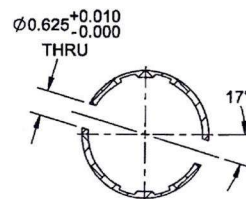
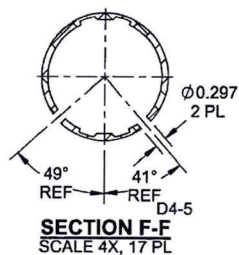
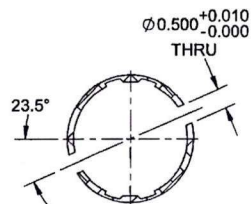
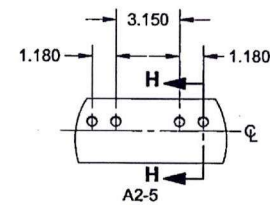
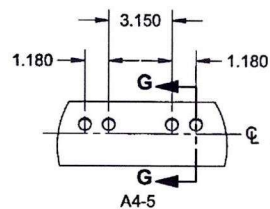
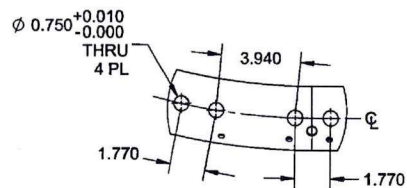
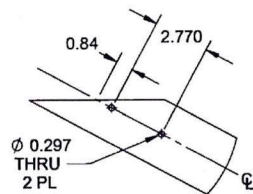
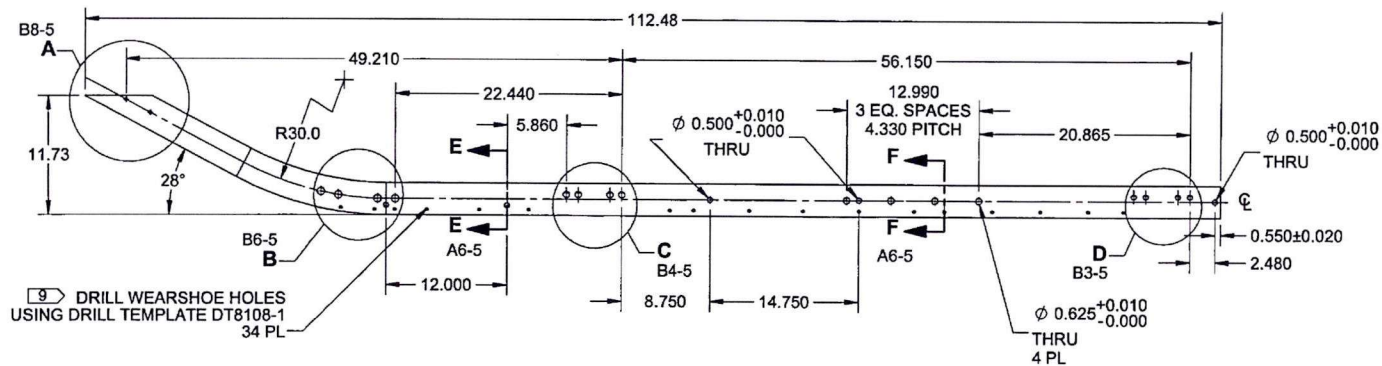
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D

C

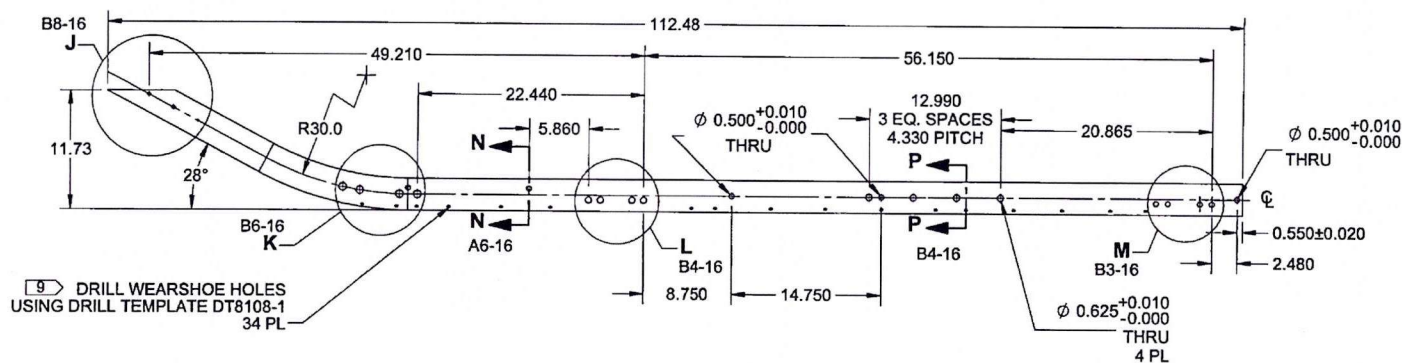
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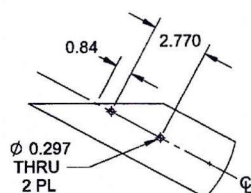


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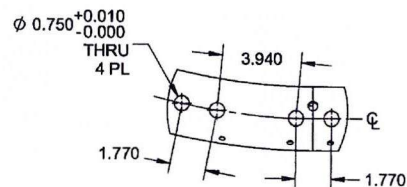
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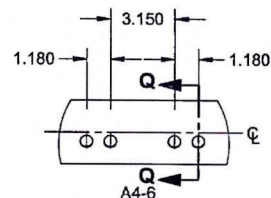
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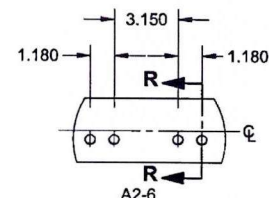
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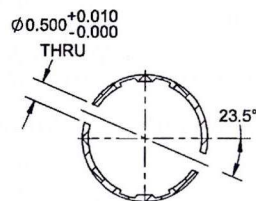
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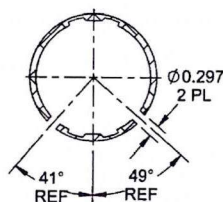
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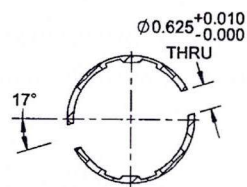
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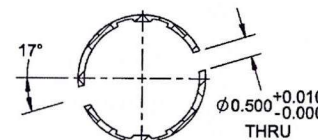
SECTION N-N
SCALE 4X, 2 PL



SECTION P-P
SCALE 4X, 17 PL



SECTION Q-Q
SCALE 4X, 4 PL

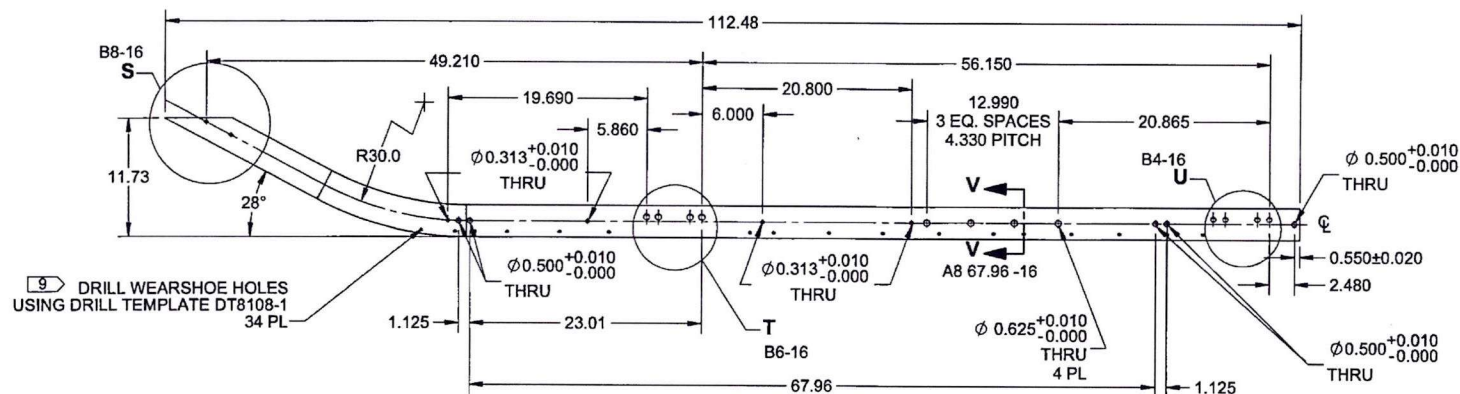


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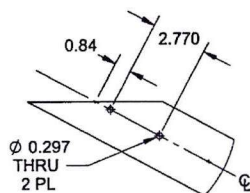
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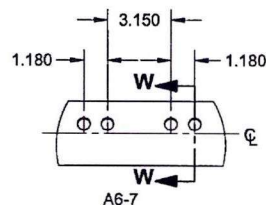
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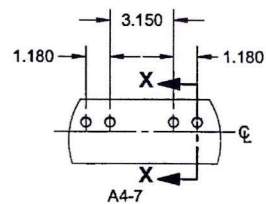
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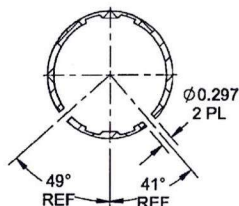
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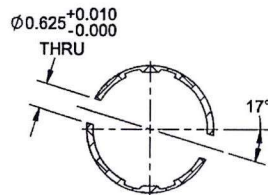
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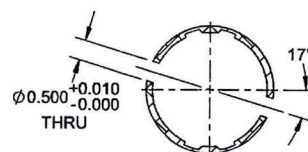
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SCALE 2X



SECTION V-V
SCALE 4X, 17 PL



SECTION W-W
SCALE 4X, 4 PL

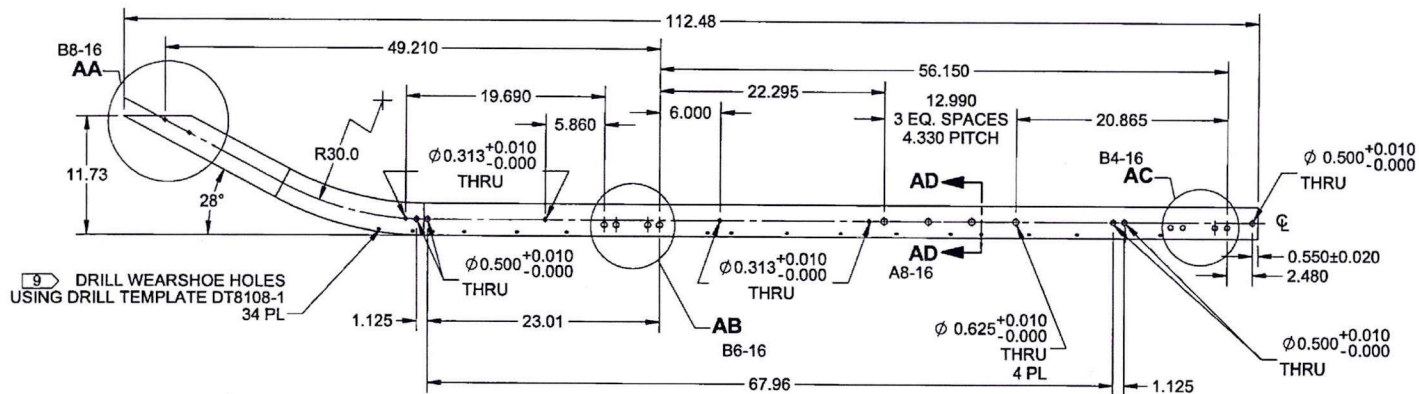


SECTION X-X
SCALE 4X, 4 PL

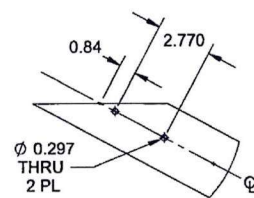
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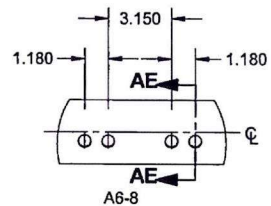
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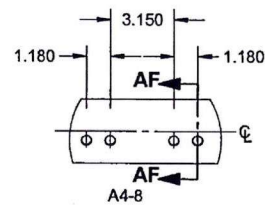
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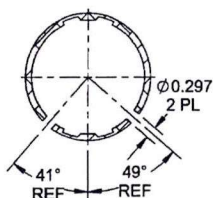
D7-8
DETAIL AA
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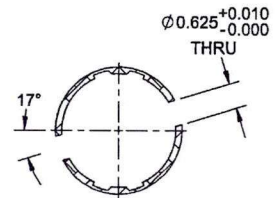
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DETAIL AB
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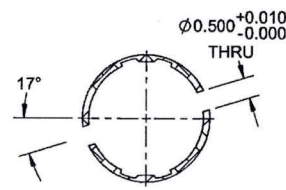
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DETAIL AC
SCALE 2X



D4-8
SECTION AD-AD
SCALE 4X, 17 PL



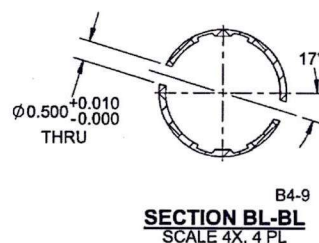
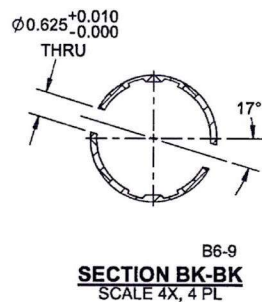
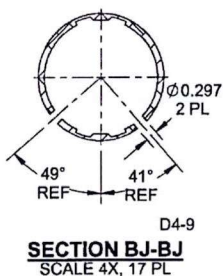
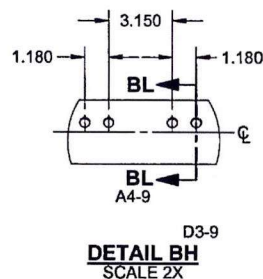
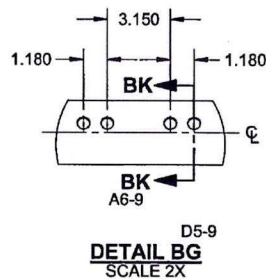
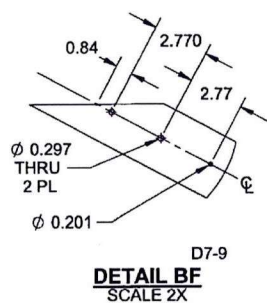
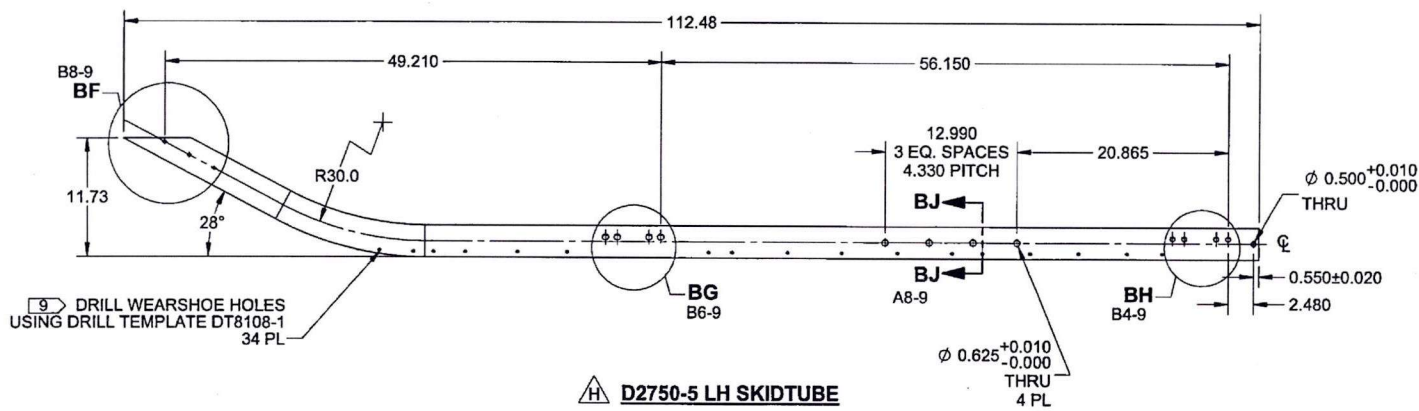
B6-8
SECTION AE-AE
SCALE 4X, 4 PL



B4-8
SECTION AF-AF
SCALE 4X, 4 PL

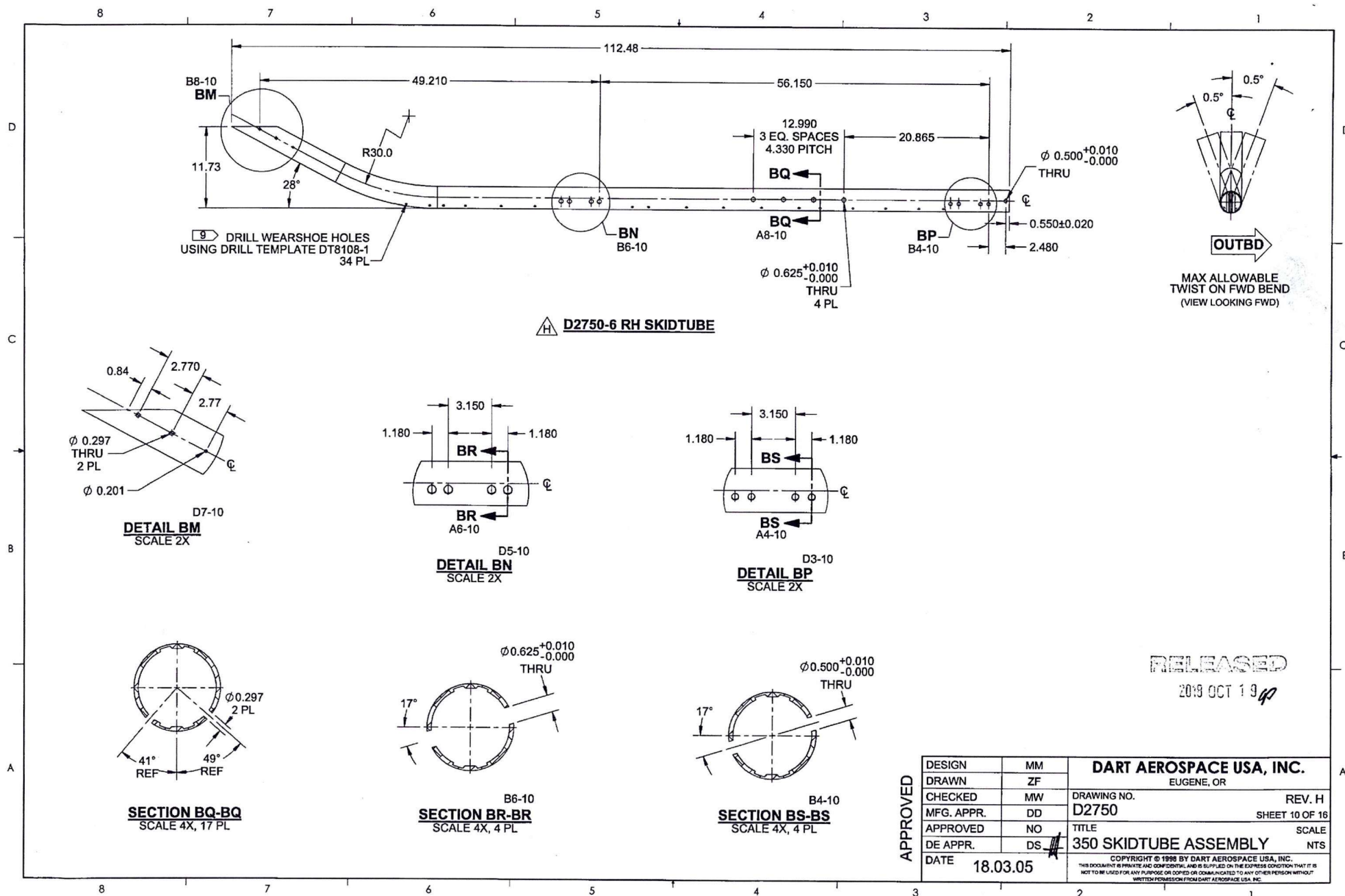
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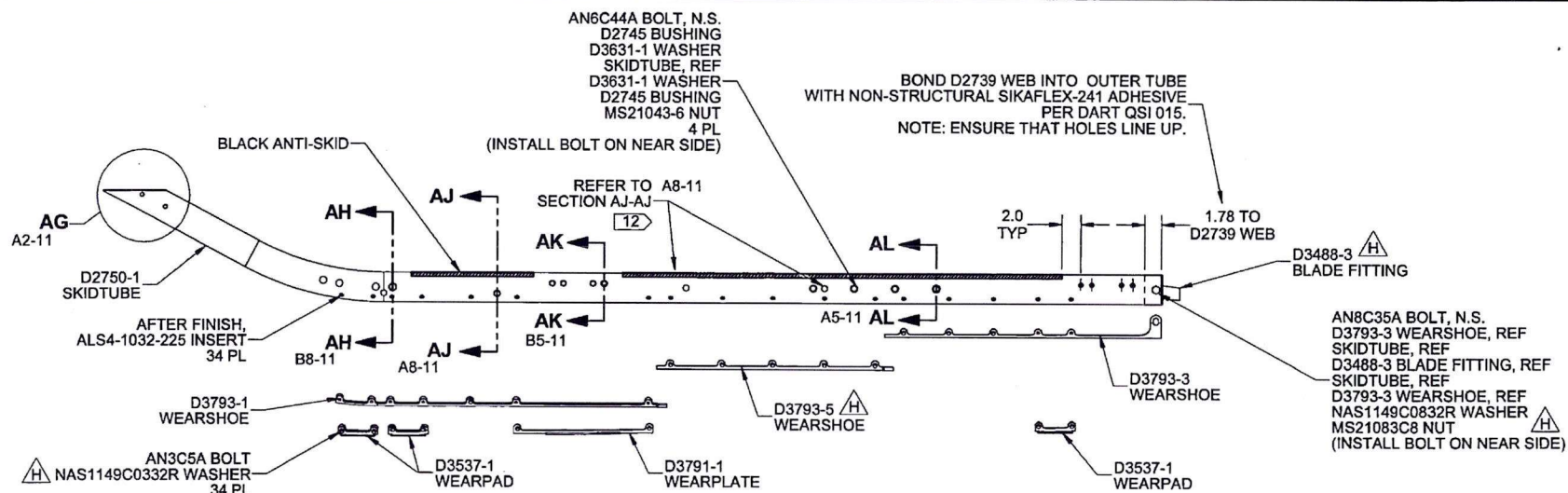
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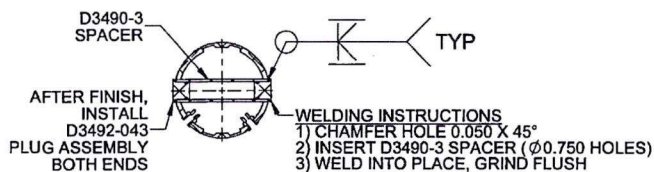
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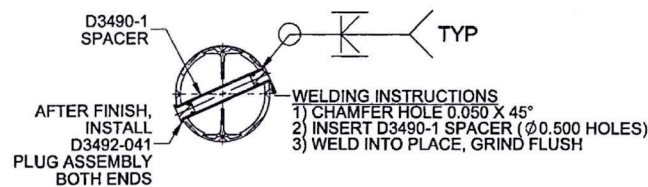
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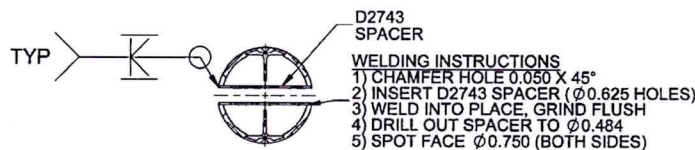
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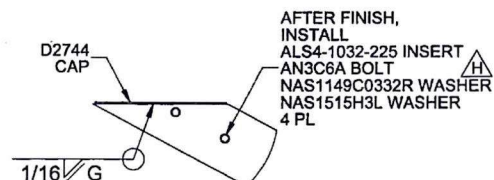
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SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
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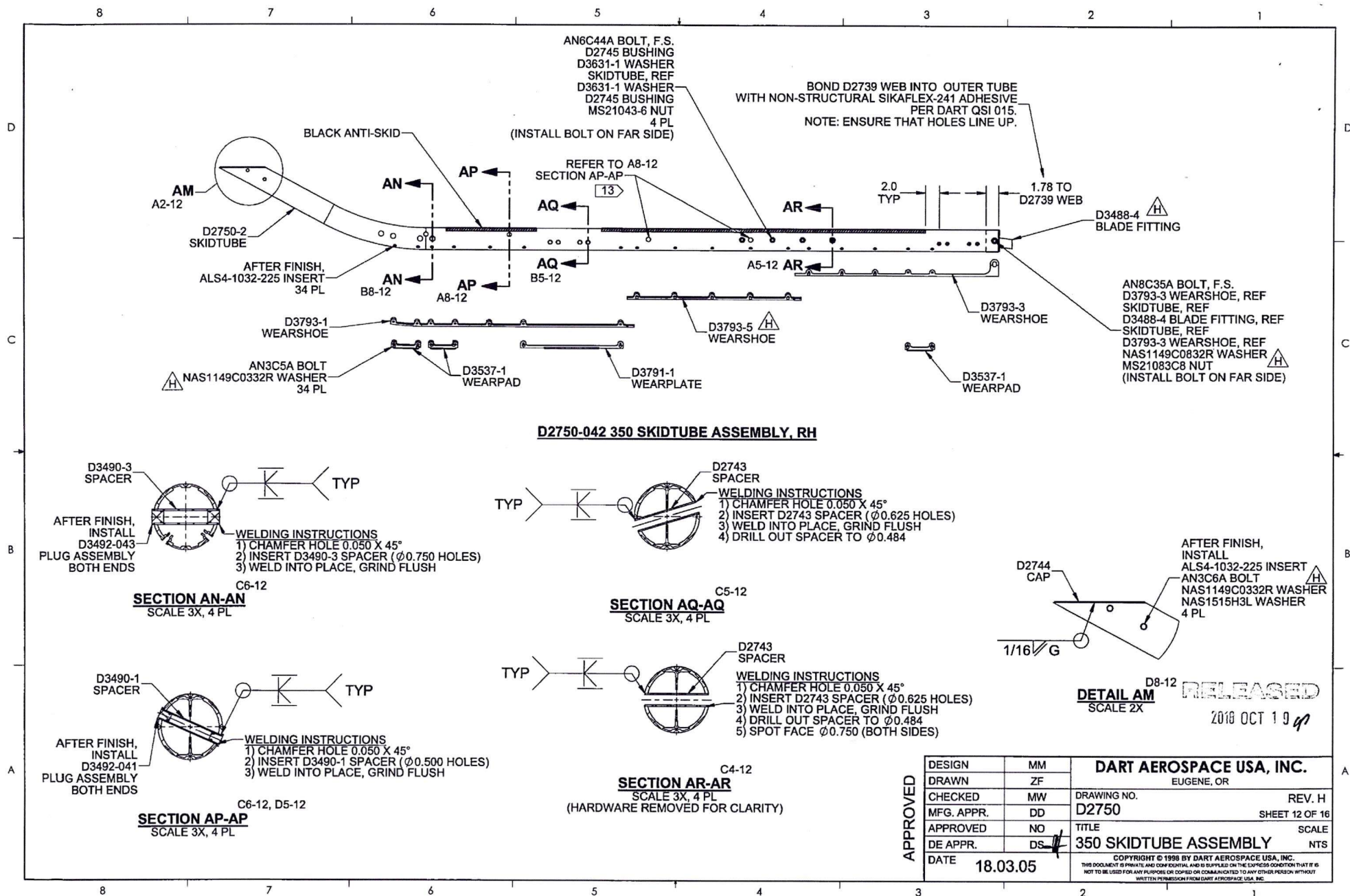


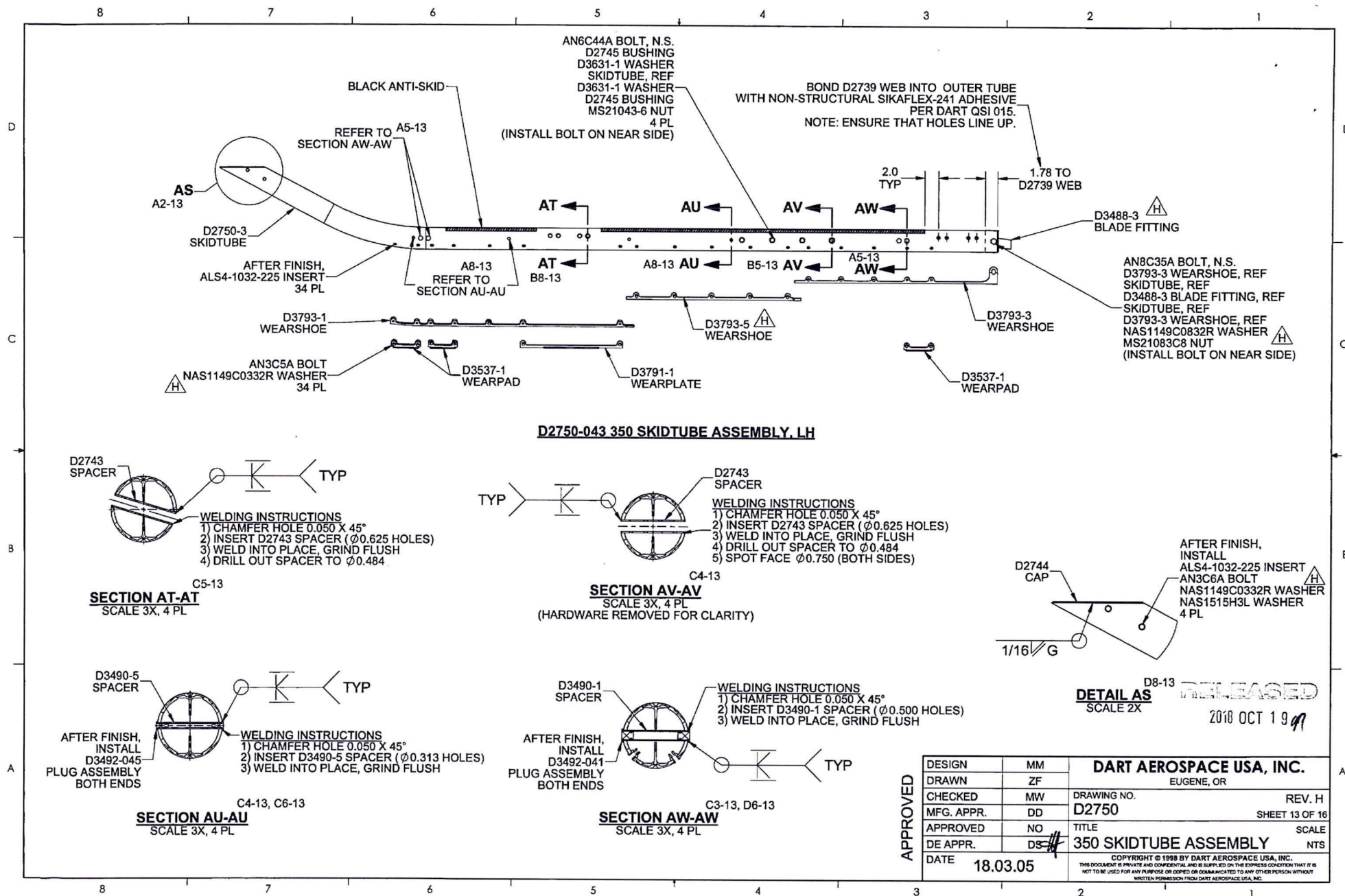
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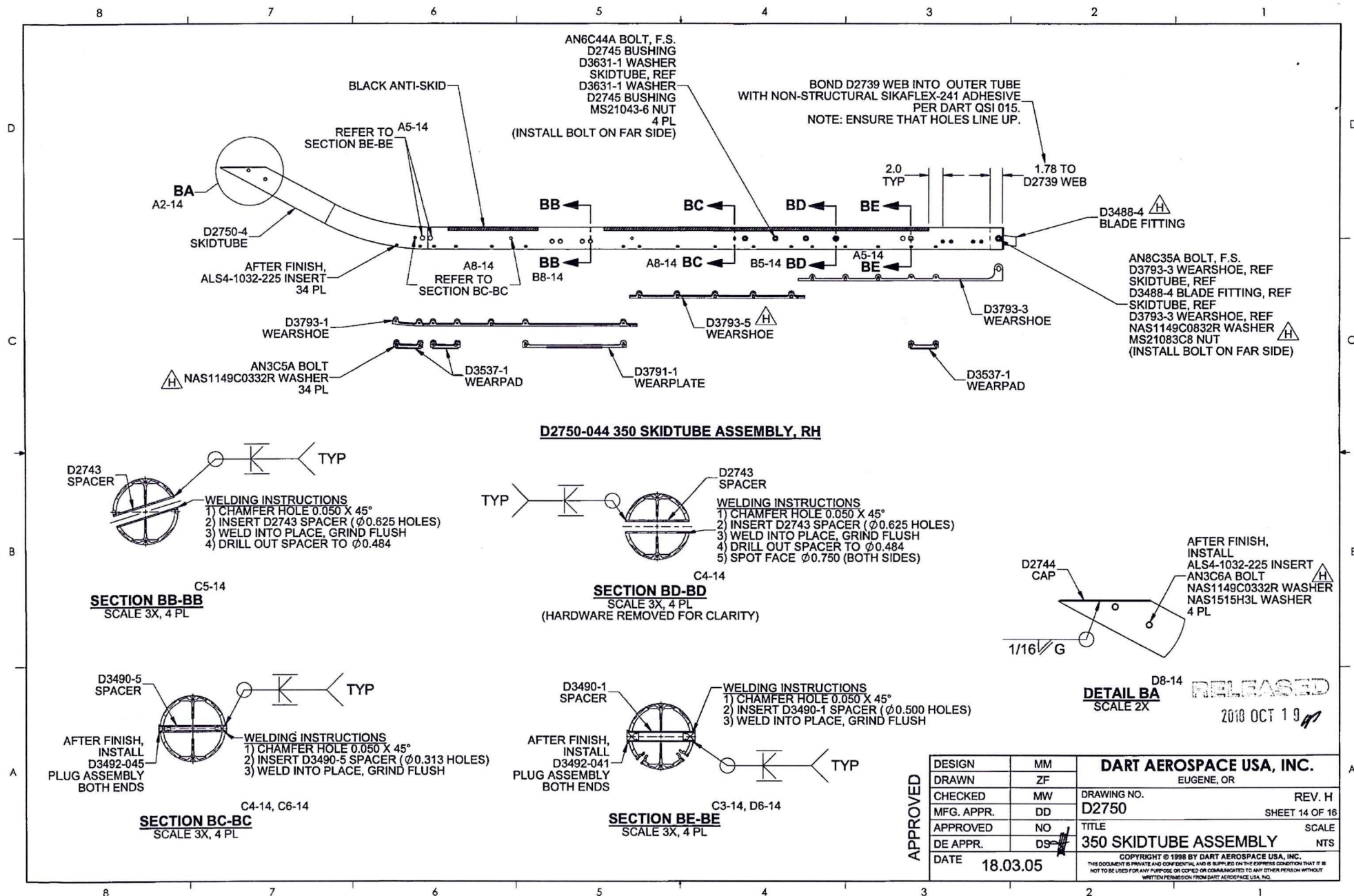
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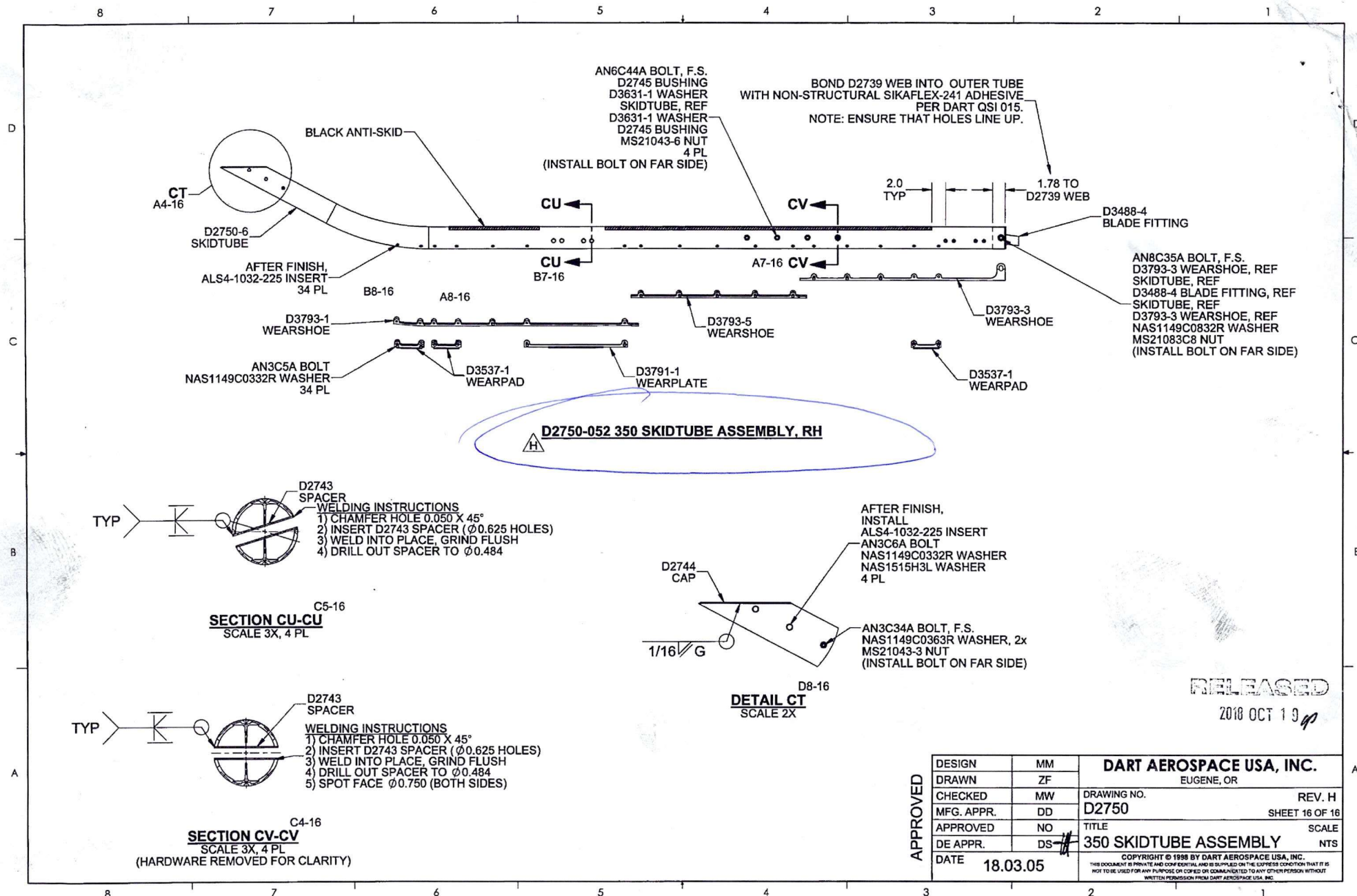
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